

Date: Thursday, 15/01/2009 11:13:19 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : END CAP
Job Number : 44779	
Estimate Number : 13262	
P.O. Number :	Part Number : D301711
This Issue : 15/01/2009 S.O. No. :	Drawing Number : D3017 REV. A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 42354	Material :
Written By :	Due Date : 22/01/2009 Qty: 16 Um: Each
Checked & Approved By : <u>JLD 09.01.15</u>	
Comment : Est Rev:A 08-04-14 now on water jet DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M4130NS049	4130 Sheet .049
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Comment: Qty.: 0.0042 sf(s)/Unit Total : 0.0672 sf(s)
 Material: AISI 4130N Sheet, 0.049" thick
 (M4130N-S049) Batch: 11612

ml 09 04 03

(16)

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3017
 Dwg Rev: A
 Prog Rev: A

2-Deburr if necessary

ml 09 04 03

(16)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

ml 09 04 03

(16)

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

S 08/04/03 (x16)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Identify and bag with light oil (Vactra oil #2), then Stock
 Location: CALL

C 09/04/06 (16)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: END CAP

Job Number: 44779

Part Number: D301711

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/09

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-04-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

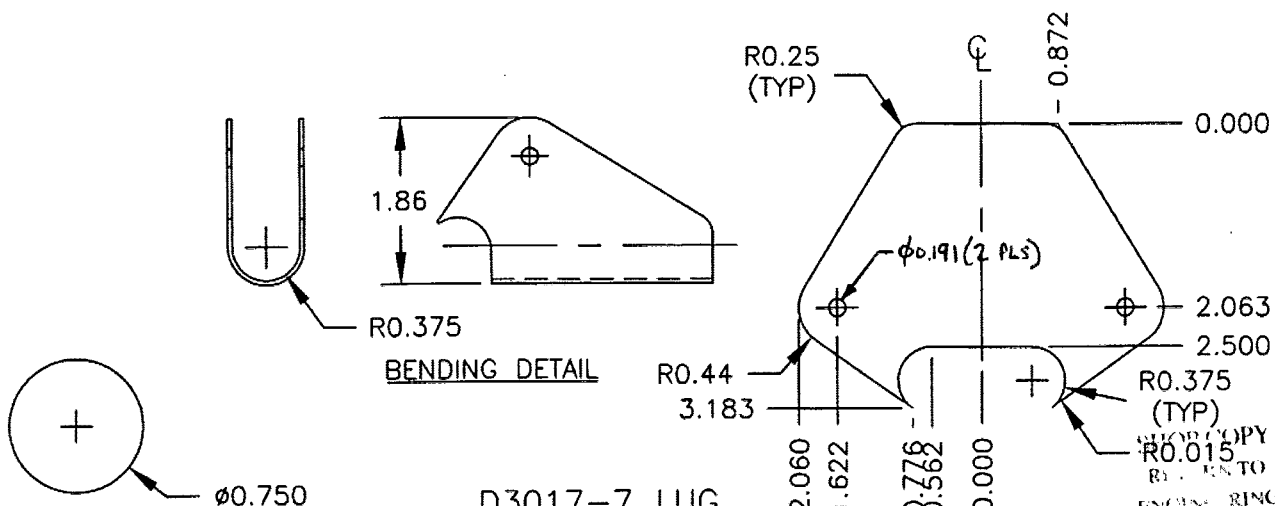
DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>A</i>	APPROVED <i>A</i>	DRAWING NO. D3017	REV. A SHEET 1 OF 2
DATE 01.05.18		TITLE BACK FRAME ASSEMBLY	SCALE 1:1
A	01.05.18	NEW ISSUE	

QTY	PART No.	DESCRIPTION	MATERIAL
X	D3017-041	BACK FRAME ASSEMBLY	N/A
1	D3017-1	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
2	D3017-3	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
1	D3017-5	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
3	D3017-7	LUG	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
2	D3017-11	END CAP	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)

NOTES

- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES.
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



D3017-11 END CAP
SCALE 1:1

D3017-7 LUG

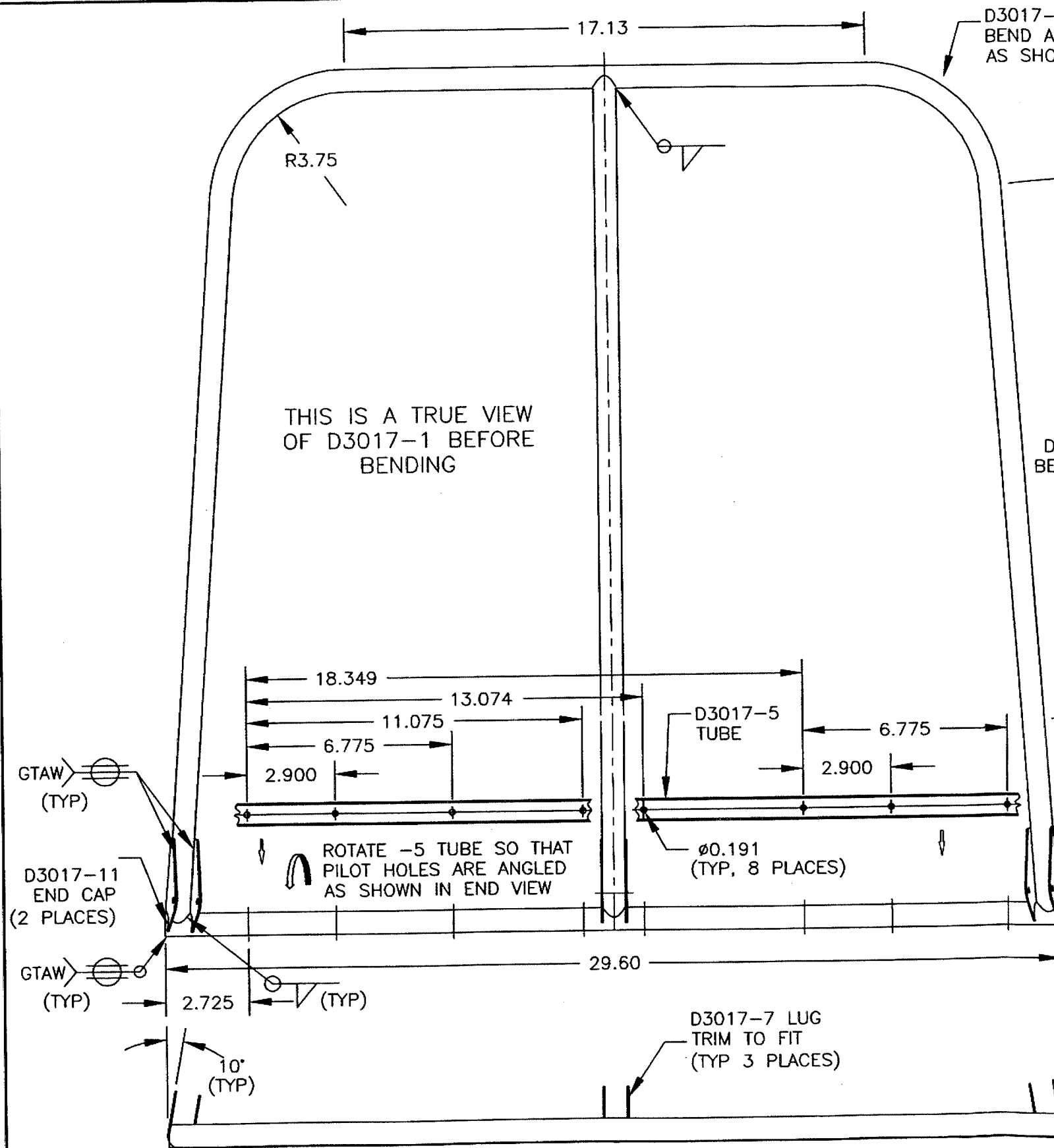
SCALE 2:1

RELEASED
01-05-30

FLAT PATTERN UNCONTROLLED COPY
PART IS SYMMETRIC ABOUT CENTERLINE
NO. 1477

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D3017-1 TUBE, BEND AND CUT AS SHOWN

17.92
DIST BETWEEN
BEND TANGENTS

DRILL Ø0.128 HOLES TO LINE UP WITH D3023-1 BACK PANEL

26.2°
ANGLE TO HOLE
CENTERLINE

22.05

27.89

R4.00

14.9°

R0.38
(TYP)

21.30

27.14

R4.00

14.9°

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WITHOUT NOTICE

D3017-3 TUBE

RELEASED
01-06-07

D3017-041 BACK FRAME ASSEMBLY
(D3017-1 TUBE, D3017-5 TUBE)

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DATE 01.05.18		TITLE BACK FRAME ASSEMBLY		SCALE 1:4	